

Work Order ID 81935

81935

Page 1

March-21-12 9:50:51 AM

Item ID: D4545-046

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Retainer, Inner, RH (Top Corner)

Start Date: 21/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ

Date: 12/03/21 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4545

B

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

0.00

110

Small Fab

Memo

0.00

Small Fab

1- ASSEMBLE AND BEND TABS AS PER DWG

2- TRANSFER DRILL HOLES AS PER DWG.

3- DISASSEMBLE AND DEBURR

4- DIMPLE HOLES AS PER DWG

12/03/21

②

FF

12-03-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81935

81935

Page 2

March-21-12 9:50:51 AM

Item ID: D4545-046 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Retainer, Inner, RH (Top Corner)
Start Date: 21/03/2012 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 04/04/2012 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							
Quality Control									

PTO

W/O: 81935		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
1203-22	145 d 146	Install notplates hose paint	<i>[Signature]</i>	12-03-22	2	<i>[Signature]</i> G3F42	<i>[Signature]</i> 1203-22	

Part No: D4545-046 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 81935

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Page 3

Item ID: D4545-046 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Retainer, Inner, RH (Top Corner)
Start Date: 21/03/2012 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 04/04/2012 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 10h35 OVEN TEMPERATURE: 320°F FINISH TIME: 11h05	0.00 0.00 m 115128				2	Q	DP	12/03/23
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	BL	12-3-23	
170 *170* Small Fab Small Fab	INSTALL NUT PLATES AS PER DWG Memo	0.00 0.00				2	FF	12-03-23	

W/O:		WORK ORDER CHANGES					
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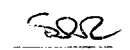

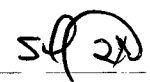

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Page 4

March-21-12 9:50:51 AM

Item ID: D4545-046 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Retainer, Inner, RH (Top Corner)
 Start Date: 21/03/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180 QC Quality Control	Memo	0.00							12/03/23 
190	Identify as per dwg & Stock Location: 	0.00							
190 Packaging Packaging	Memo	0.00							12/3/23 
200	QC21- Final Inspection - Work Order Release	0.00							
200 QC Quality Control	Memo	0.00							MLJ 12/03/26  12-03-26

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

March-21-12 9:50:56 AM

81935

D4545-046

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM
REV:B 12.02.27 AS PER DWG REV.B DD VERF:EC

IPP

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

81935 12/03/21
M.C.J.

RELEASED
2012-02-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIOR TO ASSEMBLY, POWDER COAT D4541-X & D4542-X WITH BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	90		
DRAWN	90		
CHECKED	ASS		
MFG. APPR.	13		
APPROVED	14		
DE APPR.	14		
DATE	12.02.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4545	REV. B SHEET 1 OF 9
TITLE RETAINER, INNER	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

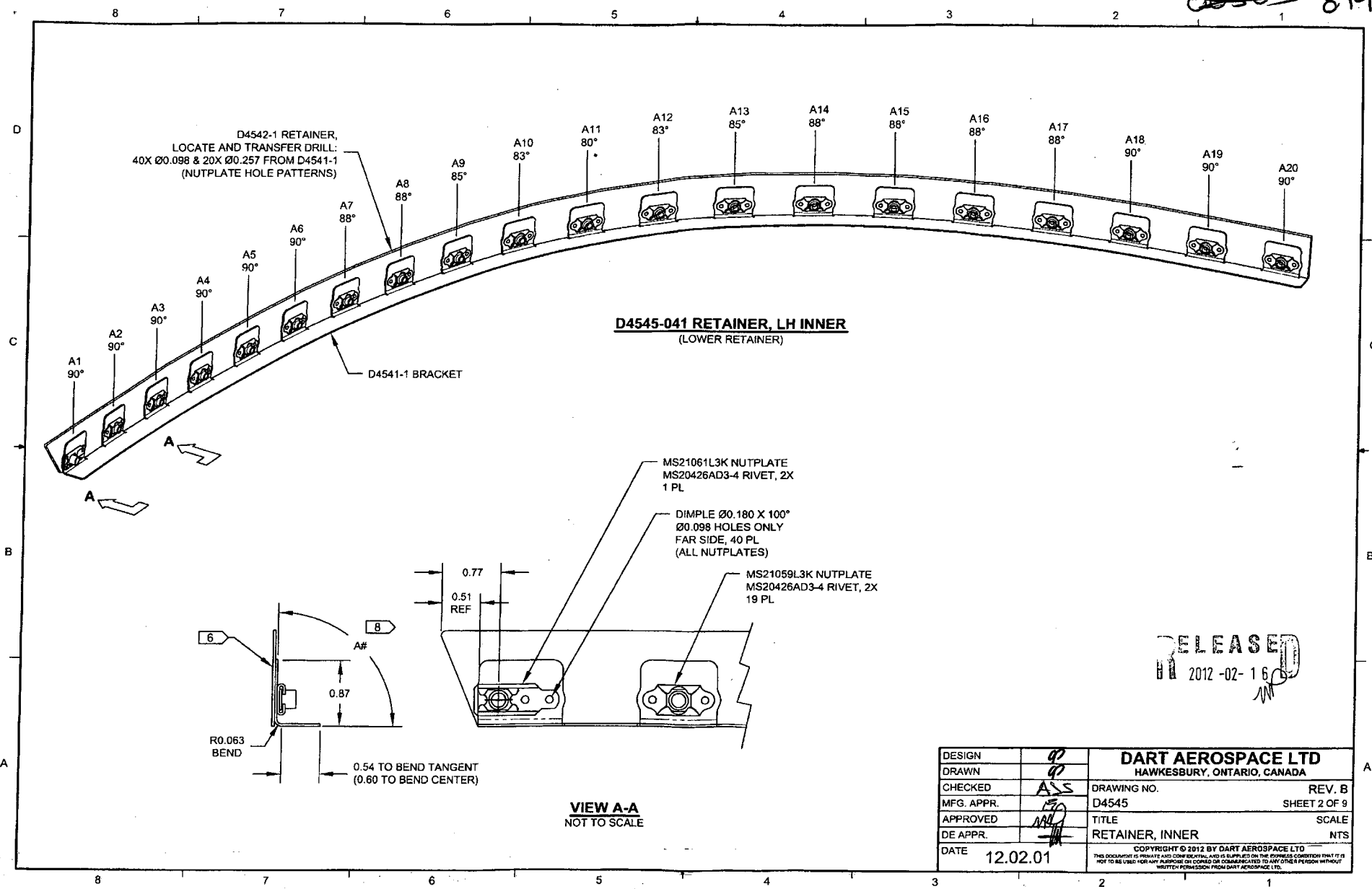
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81935



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2012-02-16

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	13	D4545	SHEET 2 OF 9
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

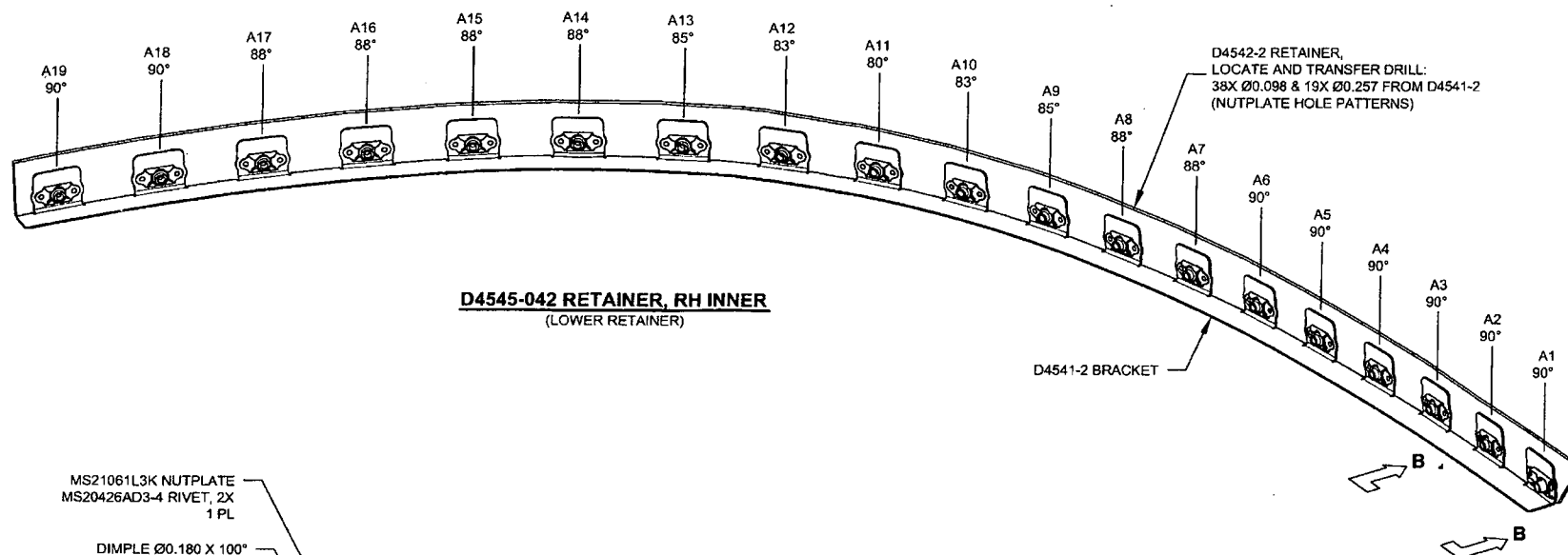
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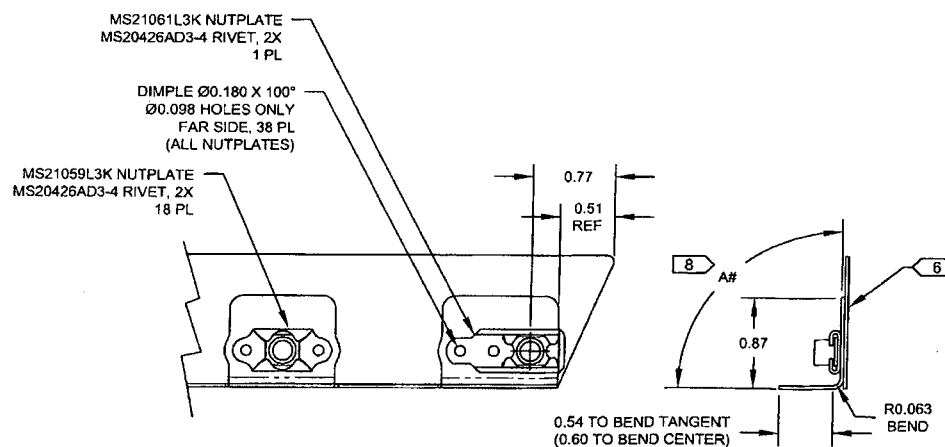
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NOTE: Date & initial all entries

81935



D4545-042 RETAINER, RH INNER
(LOWER RETAINER)



VIEW B-B
NOT TO SCALE

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2012-02-16

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DRAWN	90		
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MFG. APPR.	ED	D4545	SHEET 3 OF 9
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

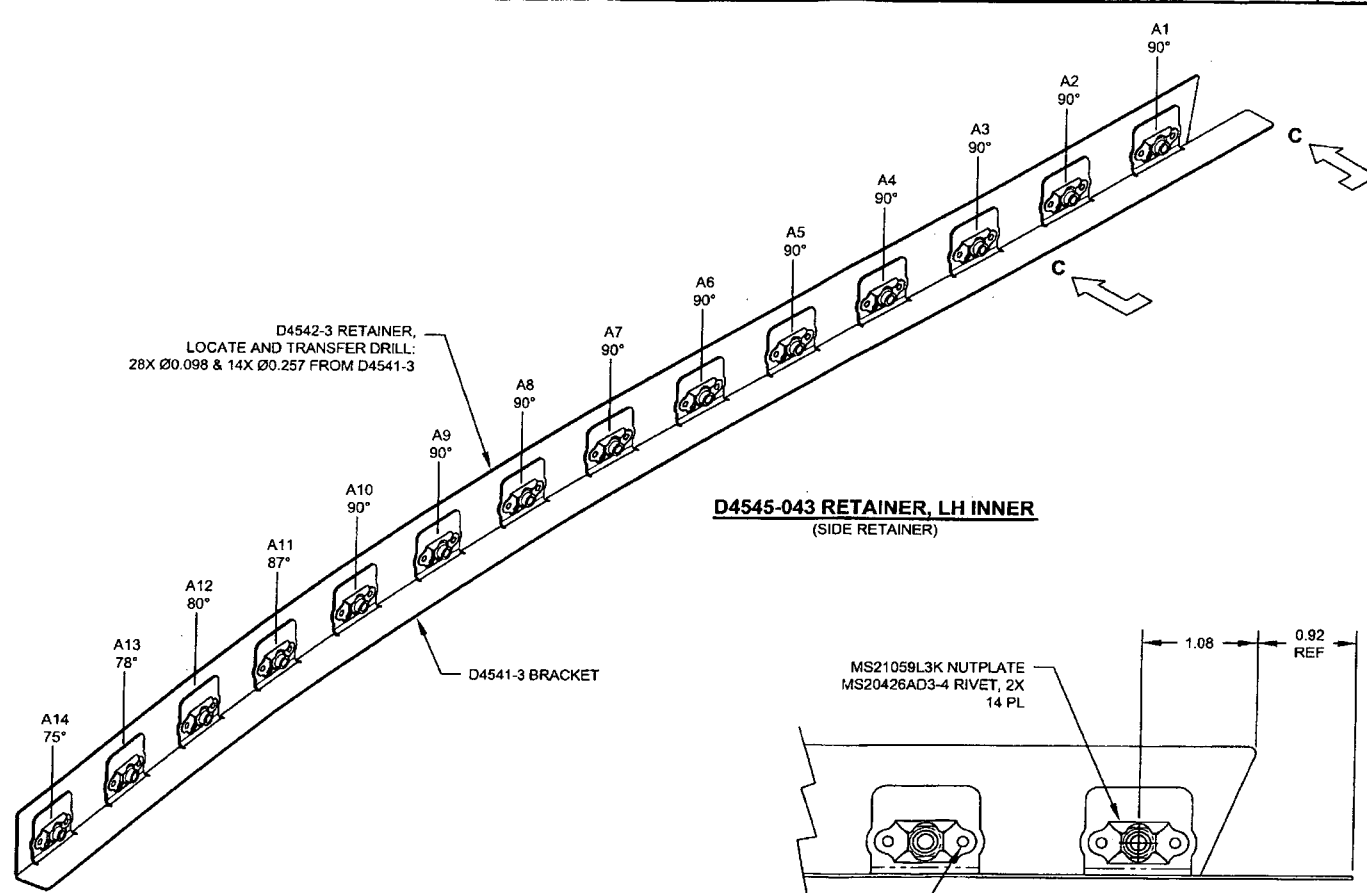
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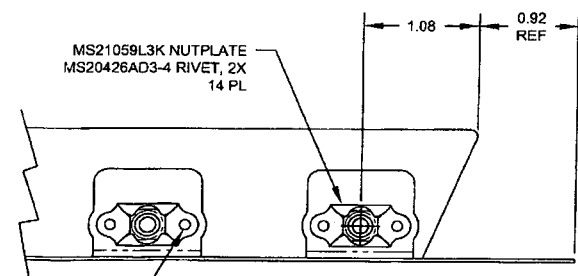
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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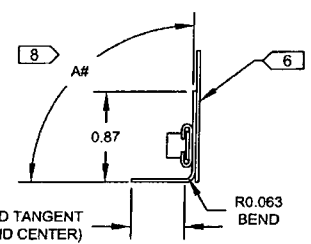
81935



D4545-043 RETAINER, LH INNER
(SIDE RETAINER)



VIEW C-C
NOT TO SCALE



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 4 OF 8
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

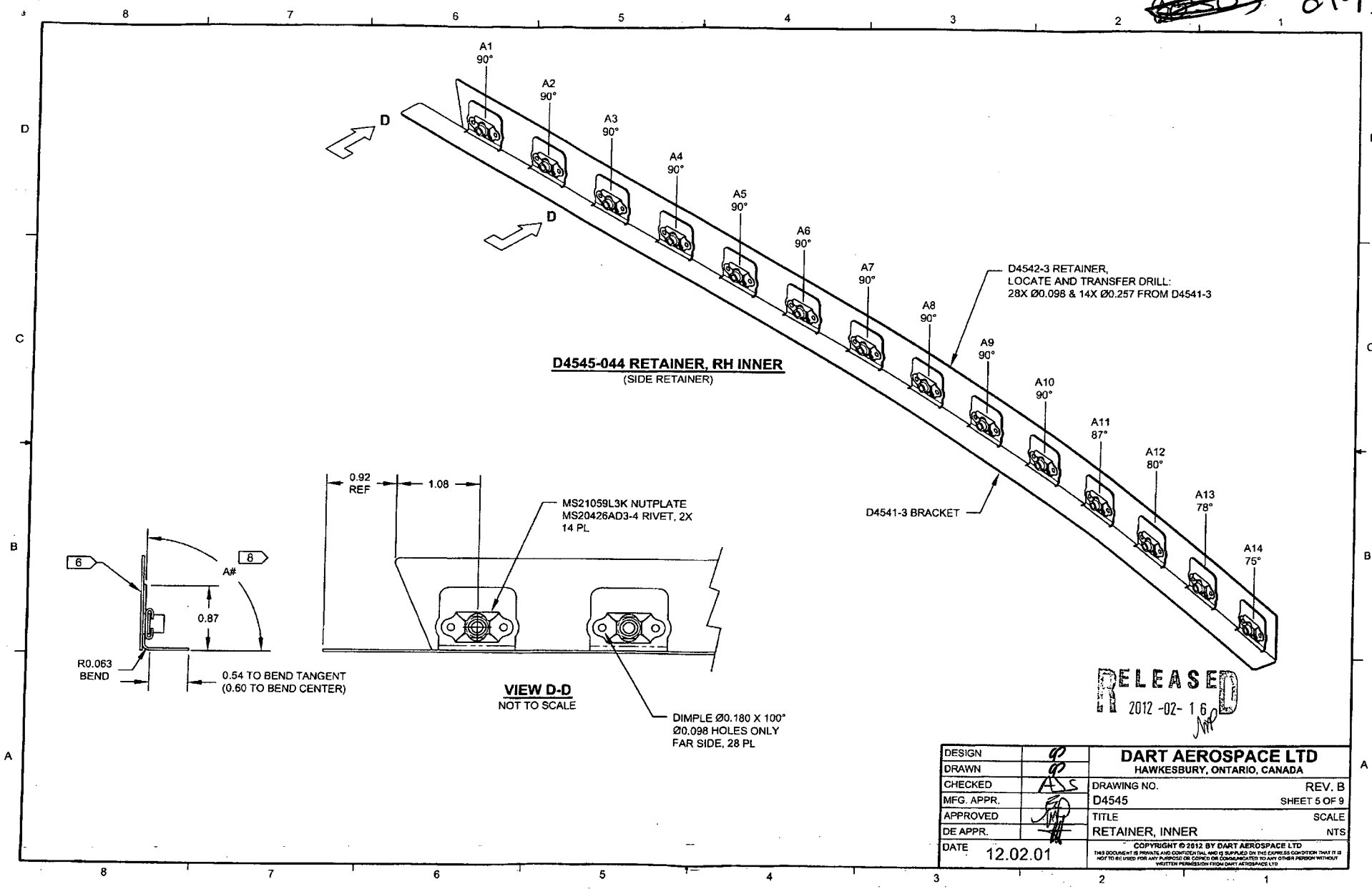
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2012-02-16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
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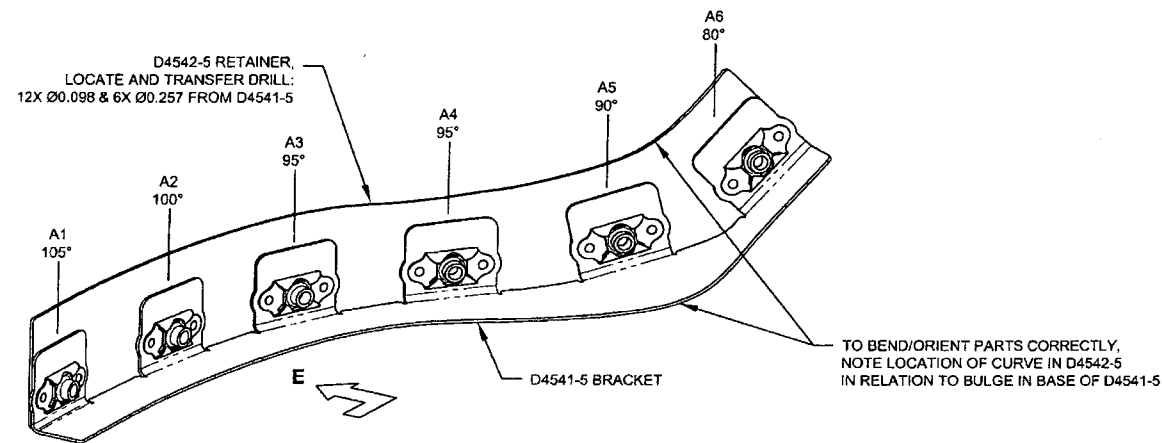
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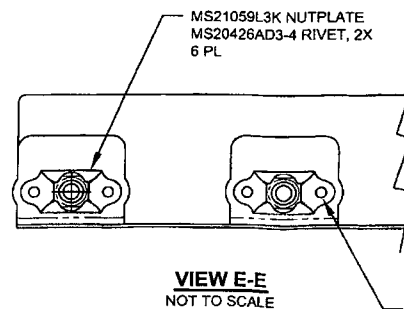
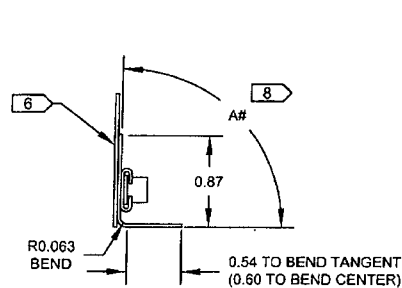
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D4545-045 RETAINER, LH INNER
(TOP CORNER RETAINER)



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2012-02-16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4545	SHEET 6 OF 9
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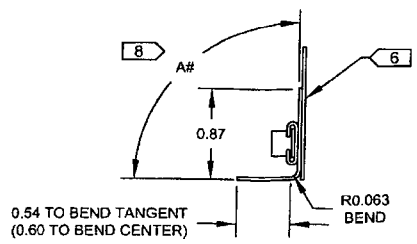
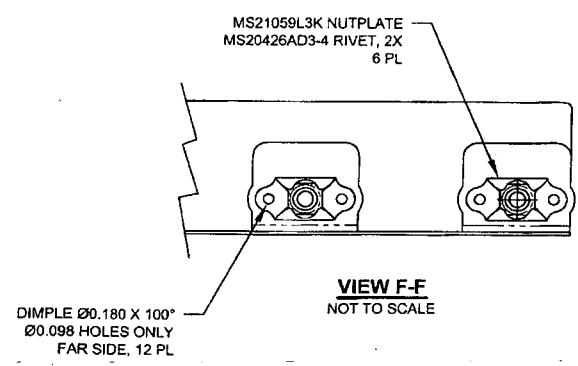
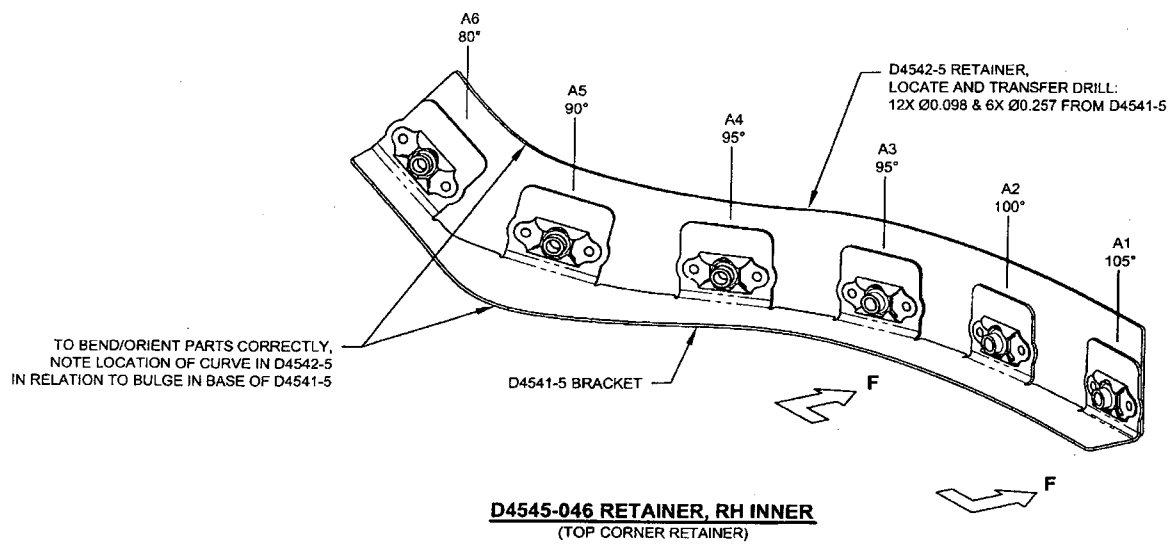
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~~80003~~ 81935



RELEASED
2012-02-16
WFO

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CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 7 OF 9
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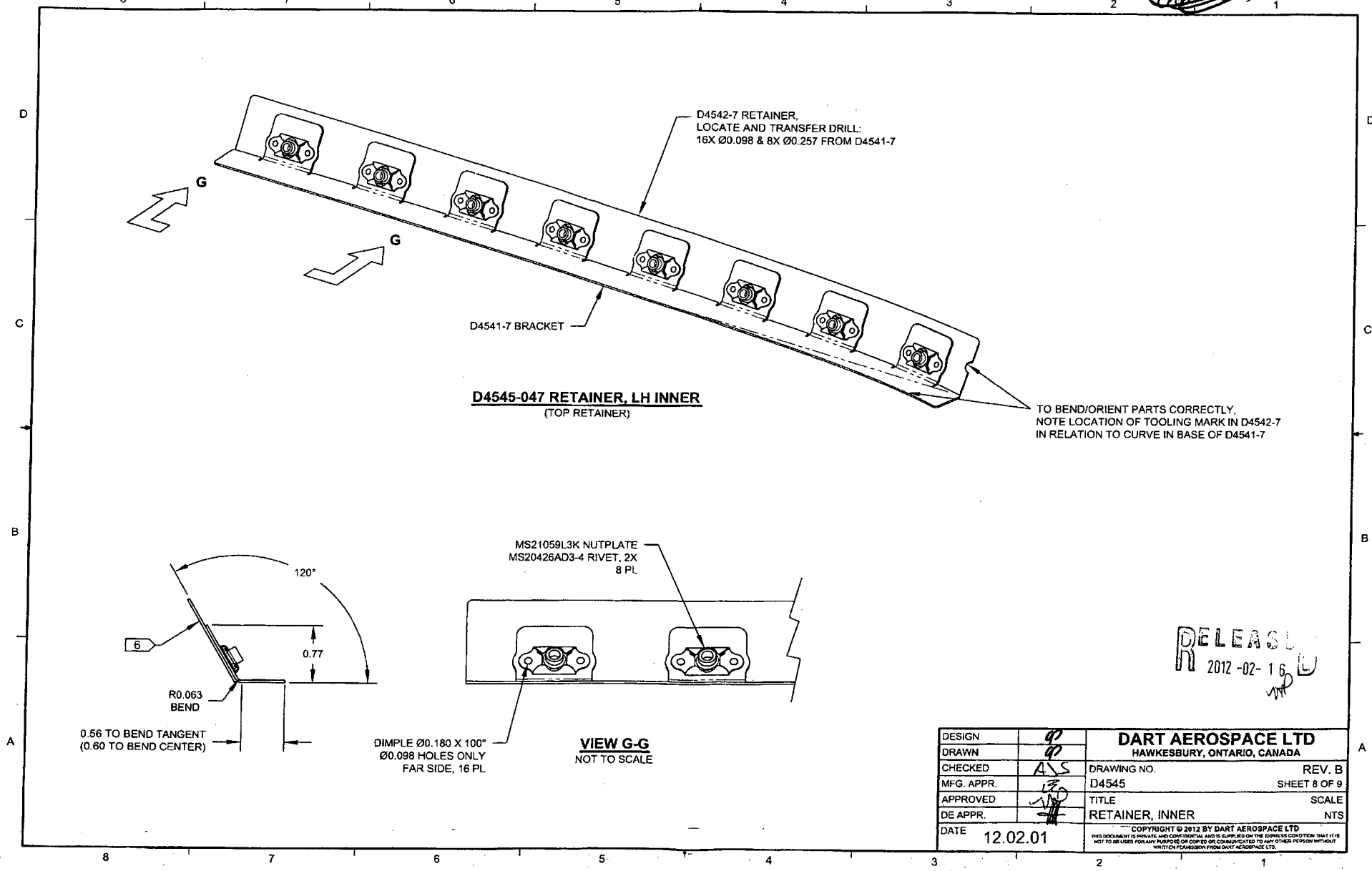
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NOTE: Date & initial all entries

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RELEASE
2012-02-16

DESIGN	40	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	40		
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	130	D4545	SHEET 8 OF 9
APPROVED	130	TITLE	SCALE
DE APPR.	130	RETAINER, INNER	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

21935

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

D4542-7 RETAINER,
LOCATE AND TRANSFER DRILL:
16X Ø0.098 & 8X Ø0.257 FROM D4541-7

D4541-7 BRACKET

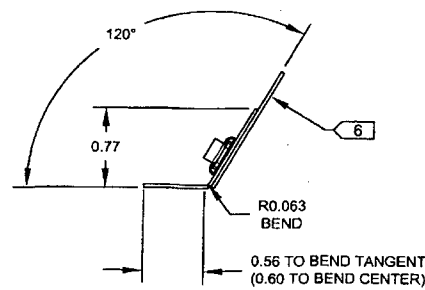
D4545-048 RETAINER, RH INNER
(TOP RETAINER)

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
8 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW H-H
NOT TO SCALE



RELEASE
2012-02-16

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	ED	D4545	SHEET 9 OF 9
APPROVED	ED	TITLE	SCALE
DE APPR.	ED	RETAINER, INNER	NTS
DATE	12.02.01	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries